

Work Order ID 72088

Tuesday, July 19, 2011 9:56:22 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: H Date: 11-07-19 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00

Large Fab

Memo

0.00

Large Fab

1- Cut D4035-1 as per dwg D4035
2- Drill as per dwg D4035 using DT9562
3- remove identification marks and deburr
4- Weld bushing in rib as per dwg D4035

11.07.20 (2)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.07.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 2011

130

Identify as per dwg & Stock Location: W/O

0.00



Packaging

Memo

0.00

Packaging

SAG 11-07-21- (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/21

ME 11-07-21

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Picklist Print

Tuesday, July 19, 2011 9:56:27 AM

Work Order ID: 72088



Parent Item: D4035-041



Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 7/19/2011


Required Date: 7/26/2011

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3  Spacer Bushing		Manufactured	No			100	Each	8.0000	1	2		11.07.20	
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Location Loc Qty Loc Code

WA 8
70884 8

M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	408.5687	1.75	3.6842		11.07.20	
---	--	-----------	----	--	--	-----	---	----------	------	--------	--	----------	--

Location Loc Qty Loc Code

MAT018 108.325209
117690 4.372109
117775 103.9531
MAT034 15.1804
117337 15.1804
WA 285.0631
118184 285.0631

3.68421

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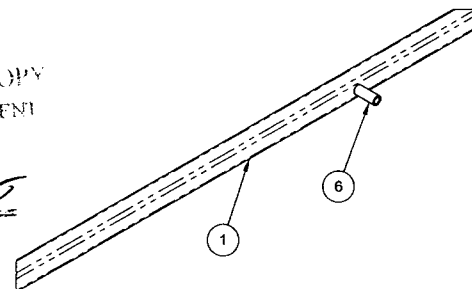
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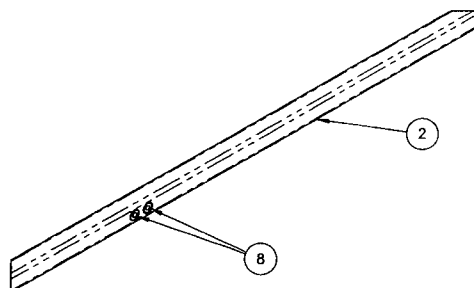
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72088

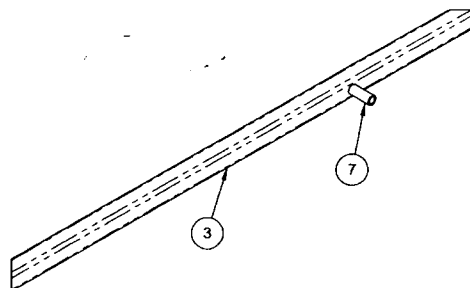
11-07-19



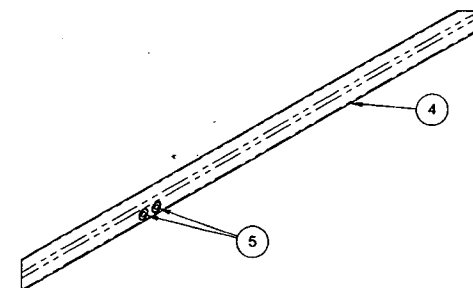
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

A		NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS			DART AEROSPACE LTD	
DRAWN	JPH			HAWKESBURY, ONTARIO, CANADA	
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D4035	SHEET 1 OF 5
APPROVED				TITLE	SCALE
DE APPR.				BASKET LID RIB ASSY	NTS
DATE		10.03.04			

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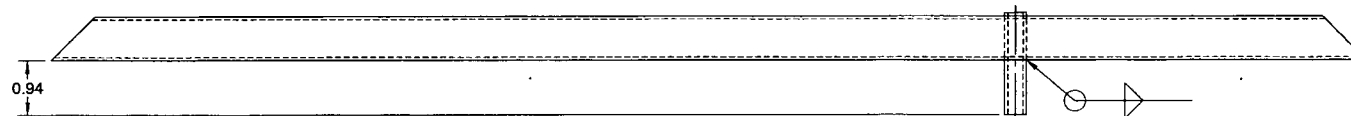
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NOTE: Date & initial all entries

172088



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12
AWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
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DE APPR.		BASKET LID RIB ASSY	NTS
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72088

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

G
G
TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
R 2010-03-12
AW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4035	SHEET 3 OF 5
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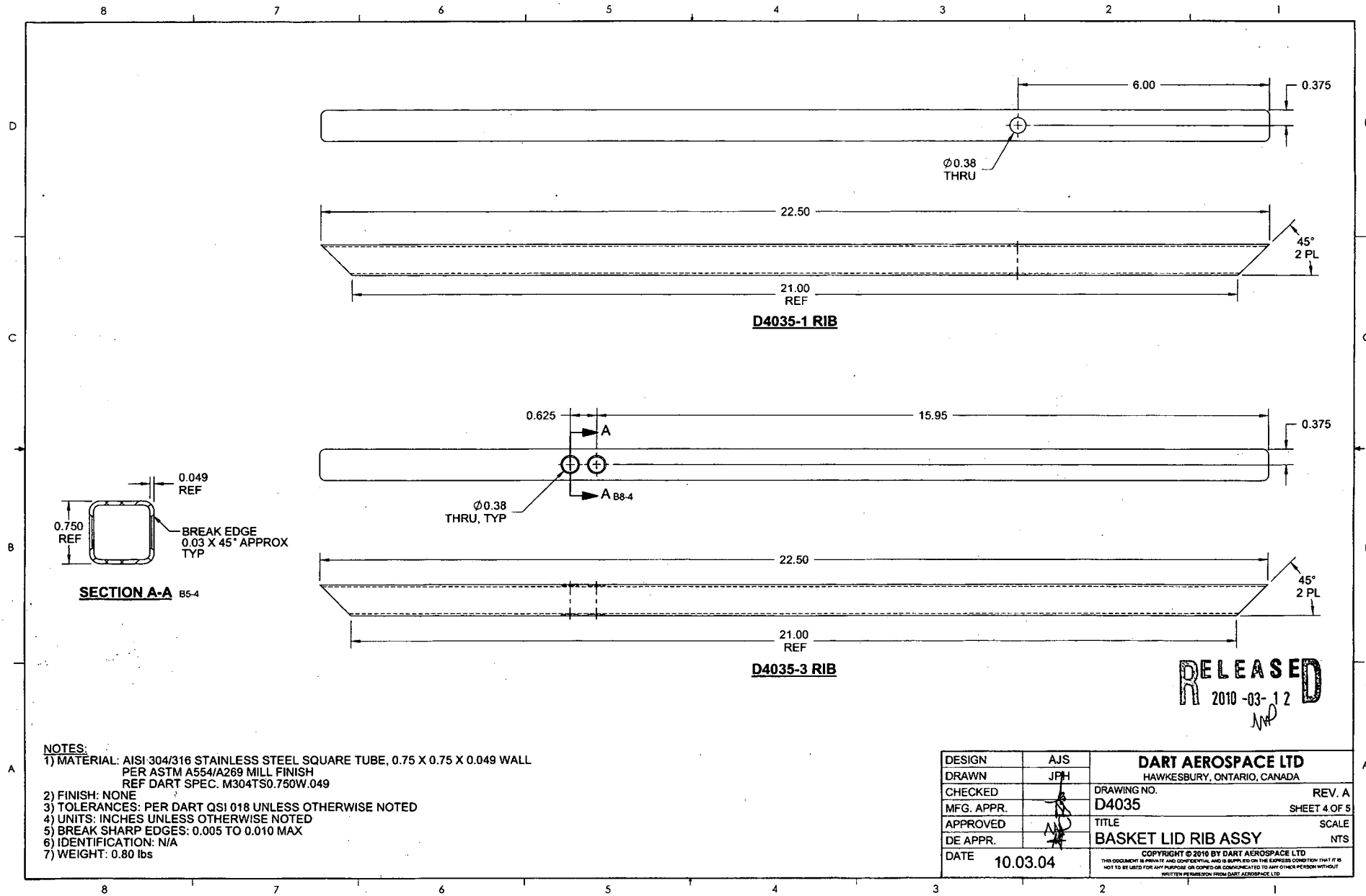
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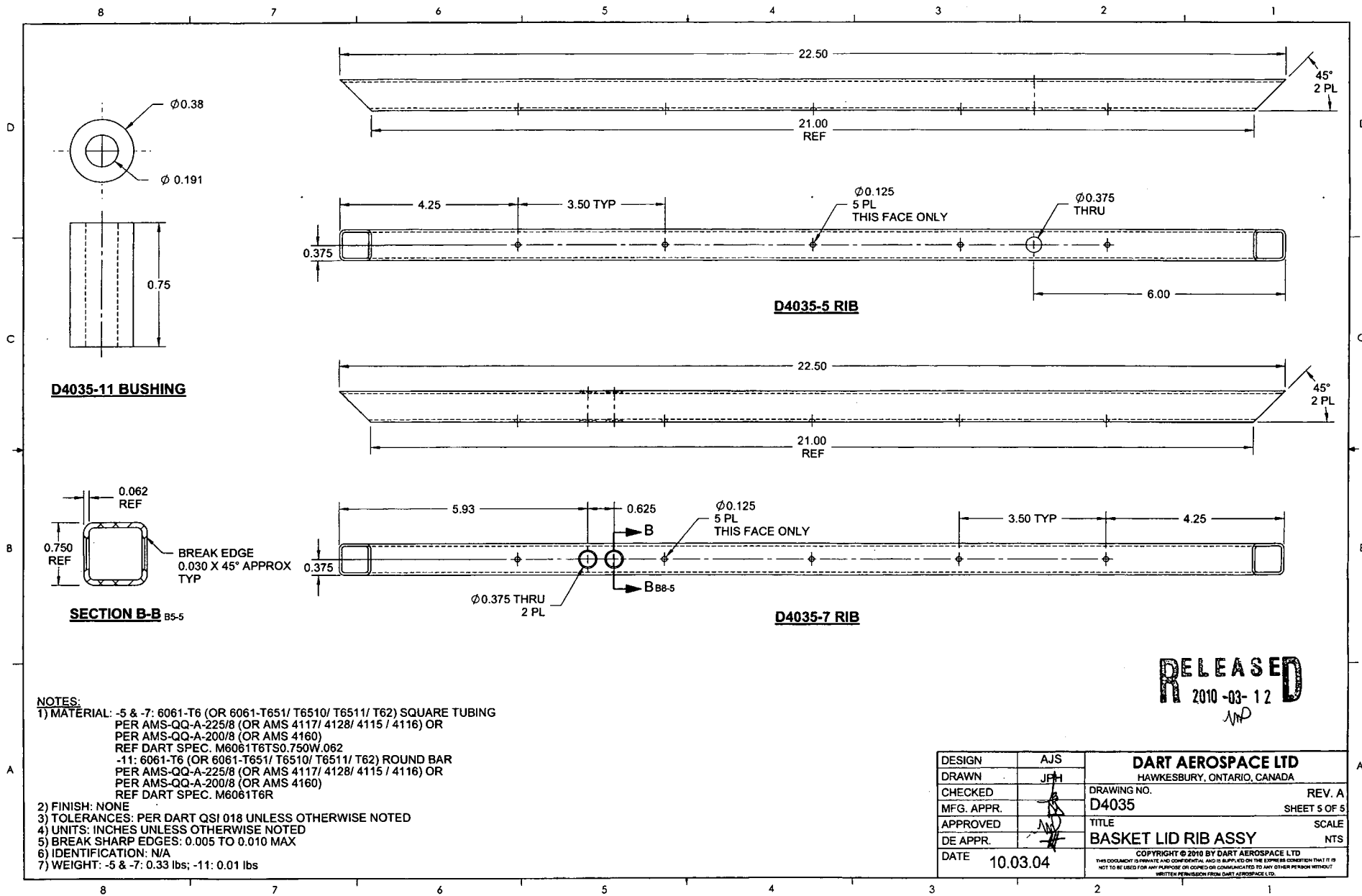
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2010-03-12
ND

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